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D4653-9

Job Sheet 201748



Part No: D4653-9

Job Qty: 24 pcs

Part Name: Fitting, Small



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/24/19

Description:

Type: SOLD

Note: DWG REV A IPP REV:A NEW ISSUE 12-06-11 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	24 pcs	10/24/19	10/24/19	0.13	3.73	Doosan - 1		10/11/16
110	QC 2	24 pcs	10/24/19	10/24/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		10/11/16

DAS
65
9-89

DAS
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9-89

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120 QC 8	24 pcs	10/24/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	DAS 23 9-86
				QC 8 - 57	WHS 19/11/18
				QC 8 - 76	
				QC 8 - 61	
130 Packaging 3-1 - Stock - B4B 24 pcs ✓		10/24/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	WAOOL-11
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	

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				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	24 pcs ✓	10/24/19	0.00 0.00	QC 21 - SA - 21 ✓	WAOOL-LL
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21
Part Op 100 - (Doosan Lathe) Descriptions: 110 - (QC2- Inspect parts off machine FA/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6R1.000	Round Bar 1.00"	3 ft (.125 ea)	100-Doosan - 1	5229456	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	M6061T6R1.000	3	54	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Small Fitting	0.807Inches + 0.000 - 0.001	0.807 0.806	Diameter	
2	Small Fitting	0.547Inches + 0.008 - 0.001	0.555 0.546	Diameter	
3	Small Fitting	0.712Inches ± 0.010	0.722 0.702	Diameter	
4	Small Fitting	0.110Inches ± 0.030	0.140 0.080		
5	Small Fitting	0.080Inches + 0.005 - 0.000	0.085 0.080		
6	Small Fitting	0.320Inches ± 0.030	0.350 0.290		
7	Small Fitting	0.630Inches ± 0.030	0.660 0.600		
8	Small Fitting	1.340Inches ± 0.030	1.370 1.310		
9	Small Fitting	45.000Degrees ± 0.500	45.500 44.500	Angle	
10	Small Fitting	0.745Inches ± 0.010	0.755 0.735	Diameter	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality		DEPARTMENT/PROCESS		MRB (QS1042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up					
Completed By		Lead hand / Supervisor					
QC / QA Coordinator		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					